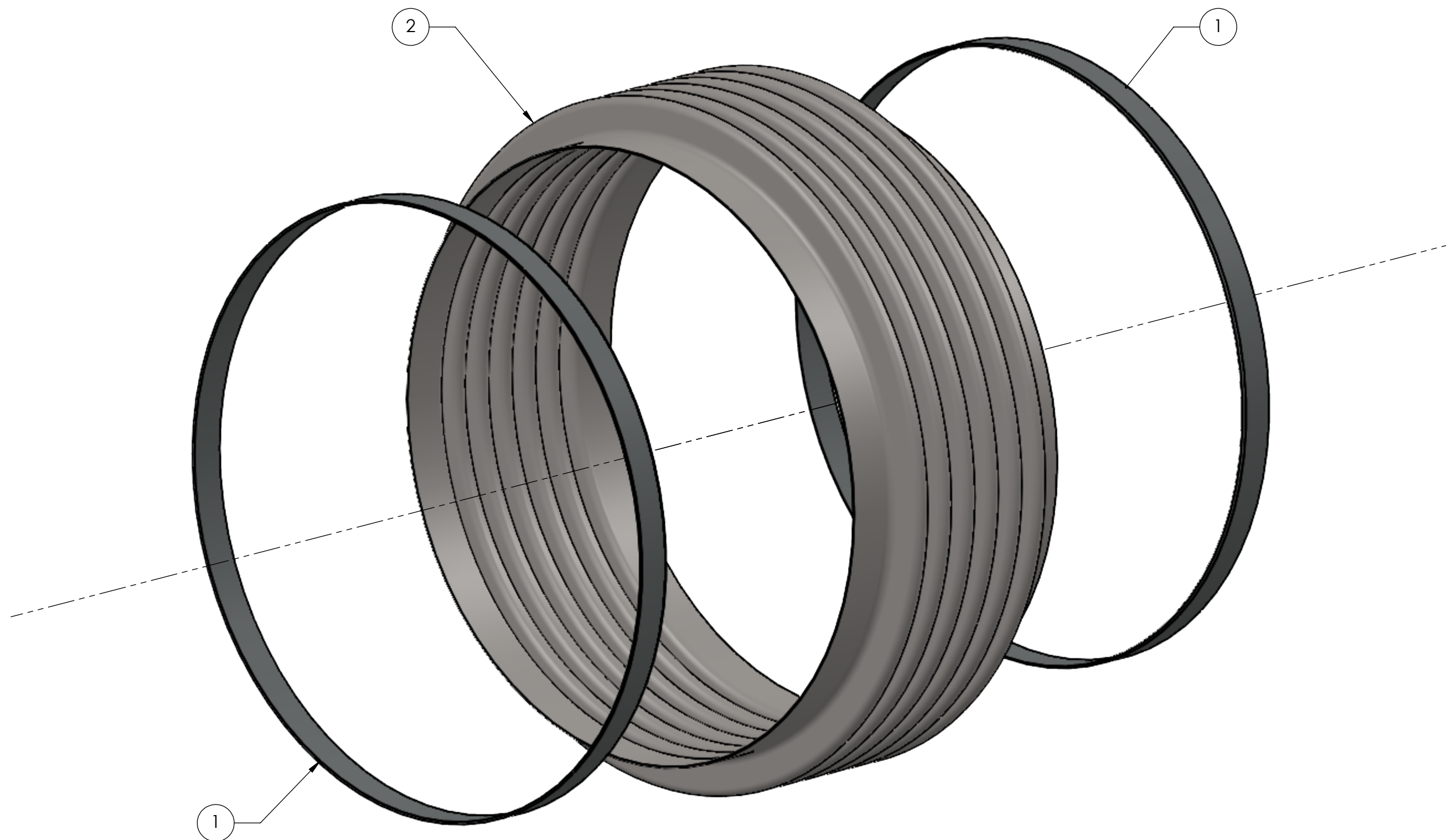


NOTES CONTINUED:

4. ~~SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR TYPE IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS. UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX~~
6. APPROXIMATE WEIGHT = 233.5 LBS.
7. ~~MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH. USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED. REFERENCE TO LIGO SPECIFICATION E9090364.~~
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E9090364.
9. ~~ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4.~~
10. ~~ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL. AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREAD-ED INSERTS.~~
11. ~~ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFERENCE TO LIGO SPECIFICATION E9090364.~~
12. SURFACE FINISH TO BE AS-PROCESSED FROM MILL/SUPPLIER, FREE FROM SCRATCHES OR GOUGES.
13. ~~PART WILL BE PORCELAIN-COATED PER LIGO SPECIFICATION E1000083 AFTER FABRICATION. THE INDICATED HOLES WILL BE MASKED PRIOR TO PORCELAIN COATING TO SUPERSEDE 2.5-3X HOLE DIAMETER CENTERED ON BOTH SIDES OF THE HOLE.~~
14. ~~REFER TO LIGO E0900408 & E0900404 FOR WELDING AND HELIUM LEAK TESTING SPECIFICATIONS.~~
15. FLANGES MUST BE PACKAGED, HANDLED AND SHIPPED IN SUCH A MANNER AS TO MAINTAIN SPECIFIED SURFACE FINISHES AND FLATNESS TOLERANCES.

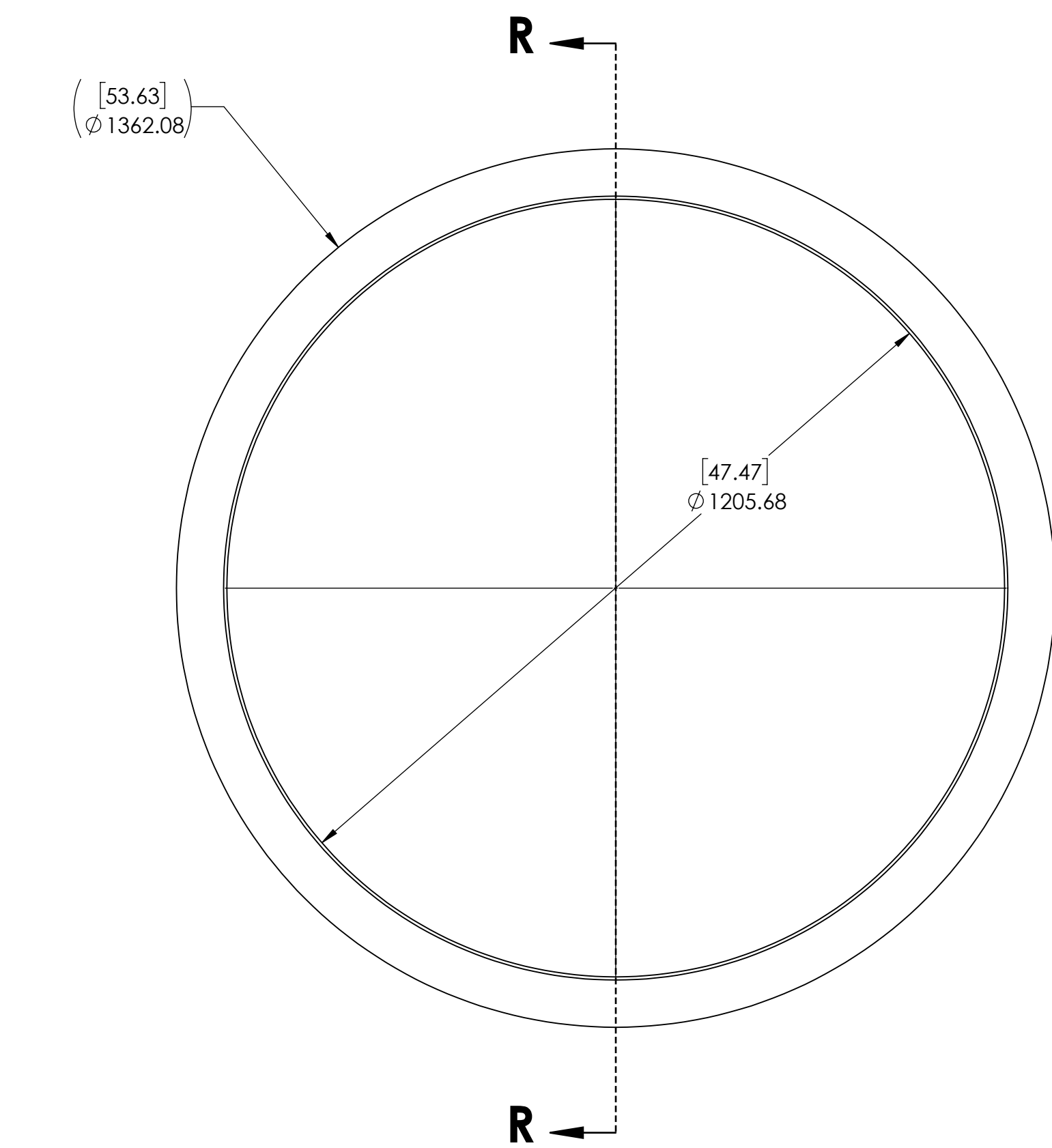
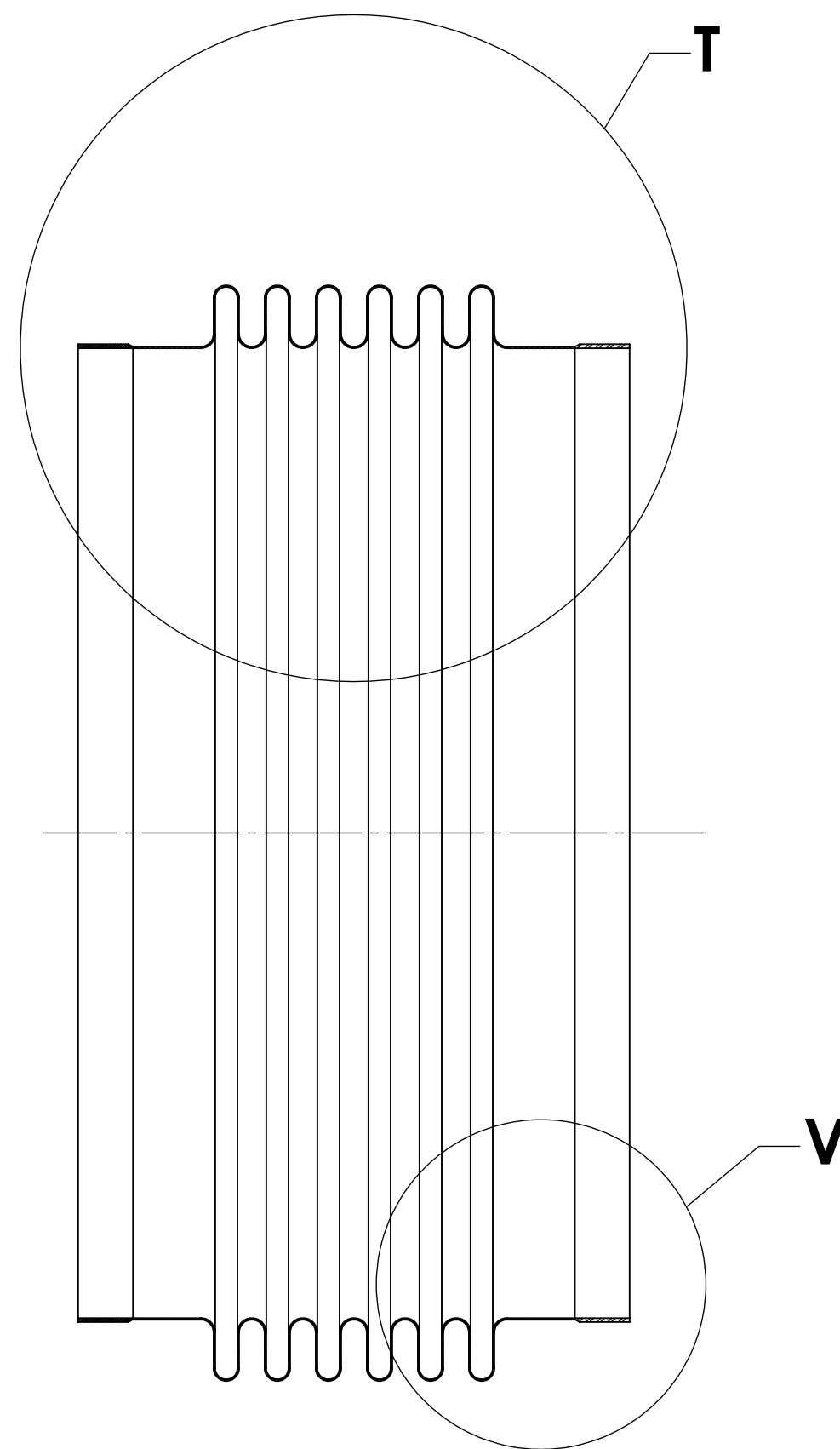


REV.	DATE	DCN #	DRAWING TREE #
v1	07/22/2026	E2600250-x0	

2	1	D2600098-01	WELDMENT, BELLOW, 48IN, 6 CONV, 304 SS			304 SS		
1	2	D2600098-02	WELDMENT, CUFF, BELLOW, 48IN, CEBEX			CARBON STL		
ITEM NO.		QTY.	PART NUMBER	DESCRIPTION			MATERIAL	SUPPLIER
Weldment Cut List								
STITUTE OF TECHNOLOGY IS INSTITUTE OF TECHNOLOGY			PART NAME EXPANSION JOINT BELLOW, 48INOD 2MMTHK 6CONV CEBEX					
SUB-SYSTEM		DESIGNER		D. COYNE	22JUL2026	SIZE DWG. NO.		REV.
SUS		DRAFTER		E. SHANKLE	23JUL2026	D		D2600098
		CHECKER		CEBEX TEAM	27JUL2026			v1
00234		APPROVAL				SCALE: 1:10	PROJECTION:	 SHEET 1 OF 2

PRELIMINARY

PART PDM VERSION: y-006
DWG PDM VERSION: y-008
D2600098



DETAIL T
SCALE 1 : 4

DETAIL V
SCALE 1 : 2

SECTION R-R
SCALE 1 : 8

PRELIMINARY